

Work Order ID 56996

Tuesday, March 16, 2010 11:35:55 AM



Page 1

Item ID: D4021-7

Accept



Setup Start



Revision ID:

Item Name: Hoop

Stop



Start Date: 3/16/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 3/22/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: *MP*

Date: 10-3-16 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D4021	A
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100	0.00
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Waterjet

Memo

0.00

10-3-23

FLOW CNC Waterjet

Cut as per dwg D4021

Prog Rev: *A*

Dwg Rev: *A*

Deburr as required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

10-3-23

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Sworbsy

0.00

X/10

130



Small Fab

Small Fab

Memo

0.00

1- make radius as per dwg
2- deburr

0.00

10X

37m-k 10/03/24

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Sworbsy

0.00

4/10

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Identify as per dwg & Stock Location:

Basket coll

0.00

M 10/03/09

(10)

Packaging

Packaging

160



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

10/03/31

R/10-3-31
(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Page 1

Tuesday, March 16, 2010 11:35:54 AM

Work Order ID: 56996



Parent Item: D4021-7



Parent Item Name: Hoop

Start Date: 3/16/2010

Required Date: 3/22/2010

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC
dwg REV.A DD 10.02.22 verified by:EC

IPP Rev:B as per

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch Purchased	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304B0.625X3.000				No		100	f	18.2218	4.3853			
304 BAR .625 X 3.00											AB10-3-23	

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

MAT	18.2218	
112320	6.9593	
112442	11.2625	112442

W/O:		WORK ORDER CHANGES					
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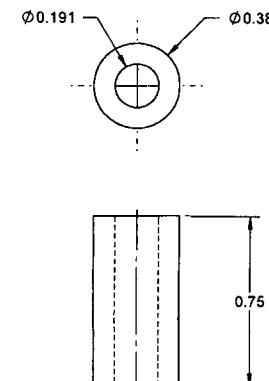
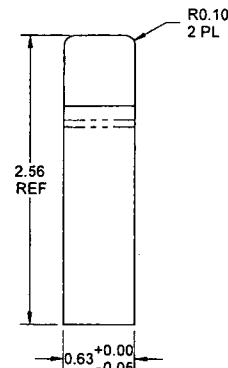
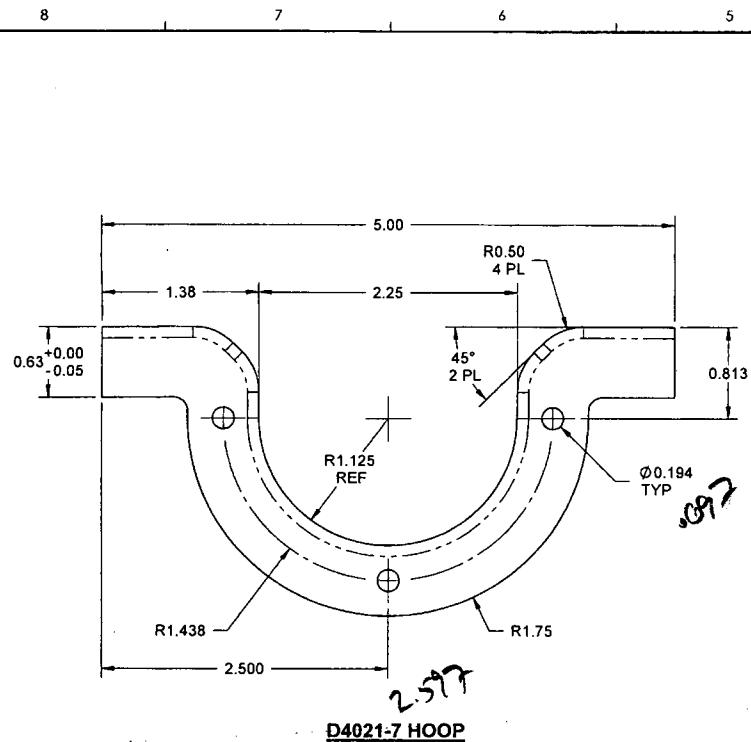
DART AEROSPACE LTD	Work Order:	S6996
Description: Hoop	Part Number:	D4021-7
Inspection Dwg: D4021-7 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	EB	Audited by:	S	Prototype Approval:	N/A
Date:	10-3-23	Date:	03/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



NOTES:

- 1) MATERIAL-7: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B
- 9: 304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276
REF DART SPEC M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -7: 0.80 lbs
-9: 0.02 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	10	DRAWING NO.	
MFG. APPR.	10	REV. A	D4021
APPROVED	10	SHEET 3 OF 3	
DE APPR.	10	TITLE	MISC PARTS - 350 BASKET
DATE	10.01.29	SCALE	NTS

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AF 56996

RELEASED
2010-02-16
JW

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